



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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RB T101530-3
Job Sheet 199225



Part No: RB T101530-3

Job Qty: 1 pcs

Part Name: Bearing Roll Stake Tool Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/14/19

Job Tracking No:

Due Date: 10/2/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG RB T101530 Rev.A IPP Rev. A 18.05.30 new issue DP Verify DD/IPP Rev. B 18.07.04 new DWG. DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	10/2/19		0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	10/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	10/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		



Container No: S207413



Part: RB T101530-3

Job No: 199225

Serial No/Batch: S207413

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/21/19

AUG 21 2019
DAS 40
9-89

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	1 pcs	10/2/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - Small Fab - 1-Assemble as per DWG. See note 8 & 9.

Descriptions: 120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____ Bag and tag. See note 10.

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MS21042-4	Nut	1 Ea (1 ea)	110-Small Fab - 1	5089336
RB T101530-11-PO	Bearing Roll Stake Roller	2 pcs (2 ea)	110-Small Fab - 1	509905
RB T101530-13	Base	1 pcs (1 ea)	110-Small Fab - 1	5134090
RB T101530-15	Bolt	1 pcs (1 ea)	110-Small Fab - 1	5148420
RB T101530-7	Bearing Roll Stake Body	1 pcs (1 ea)	110-Small Fab - 1	5147811
RB T101530-9	Roller	2 pcs (2 ea)	110-Small Fab - 1	5067328 1X 5066659

Job Allocations

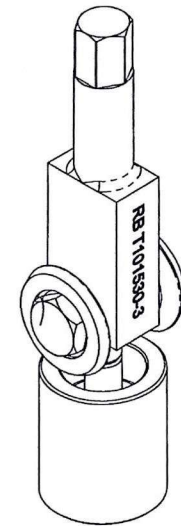
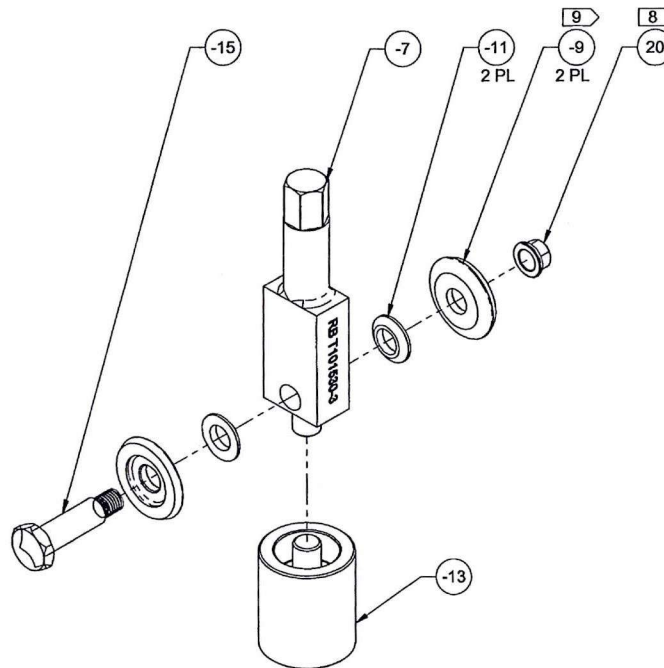
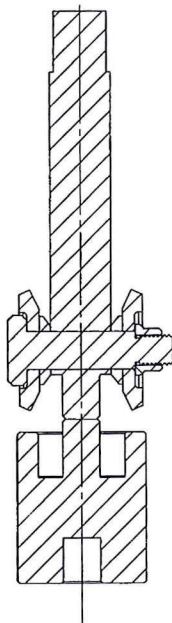
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	MS21042-4	1	91	0
	RB T101530-11	2	24	0
	RB T101530-13	1	3	0
	RB T101530-15	1	8	0
	RB T101530-7	1	2	0
	RB T101530-9	2	2	0

Part Specifications

Specifications could not be found.

Plex 8/20/19 3:18 PM dart.leclair.mathieu

ITEM #	QTY	PART #	PART TITLE
-7	1	RB T101530-7	BODY
-9	2	RB T101530-9	ROLLER
-11	2	RB T101530-11	SPACER
-13	1	RB T101530-13	BASE
-15	1	RB T101530-15	BOLT
20	1	MS21043-4	1/4"-28 LOCKNUT, STAINLESS STEEL



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN, TORQUE ITEM 20 TO 50-70 IN/LBS.
- 9) ITEMS -9 MUST ROTATE FREELY.
- 10) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG.

RB T101530-3 BEARING ROLL STAKE TOOL 10

DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>ML</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101530	SHEET 2 OF 10
APPROVED	<i>ML</i>	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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